

Date: Tuesday, 23/12/2008 12:53:26 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 A/B HIGH GEAR WEB		
Job Number	: 44280		Part Number	: D26543		
Estimate Number	: 10455		Drawing Number	: D2654 REV E1		
P.O. Number	:		Project Number	: N/A		
This Issue	: 23/12/2008	S.O. No. :	Drawing Revision	: E1		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: SKIDTUBES			
Previous Run	: 43850		Due Date	: 05/01/2009		Qty: 4 Um: Each
Written By	:					
Checked & Approved By	:					
Comment	: Est Rev:D, 99.02.04 Fixed typo, Changed procedure DM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D26005108	Extrusion 'I Beam' thin		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)				
Pick: <i>DP 8-12-29</i>				
Qty	Part Number	Description	Batch	
1	D2600-5	Web	<i>B38589</i>	
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1		
Comment: LANDING GEAR RESOURCE 1				
1-Cut D2600-5 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654 3-Using the uni-bit, open holes to finish size as per Dwg D2654 4-Deburr holes and ends				
3.0	QC5	INSPECT WORK TO CURRENT STEP		
Comment: INSPECT WORK TO CURRENT STEP				
4.0	HAND FINISHING1.	HAND FINISHING RESOURCE #1		
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1				
<i>SL 8-12-30</i>				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 44280

Part Number: D26543

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



8-12-31

4

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Skirtubell*

8-12-31

4

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/01/08

MP 08-12-31

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng			

NOTE: Date & initial all entries

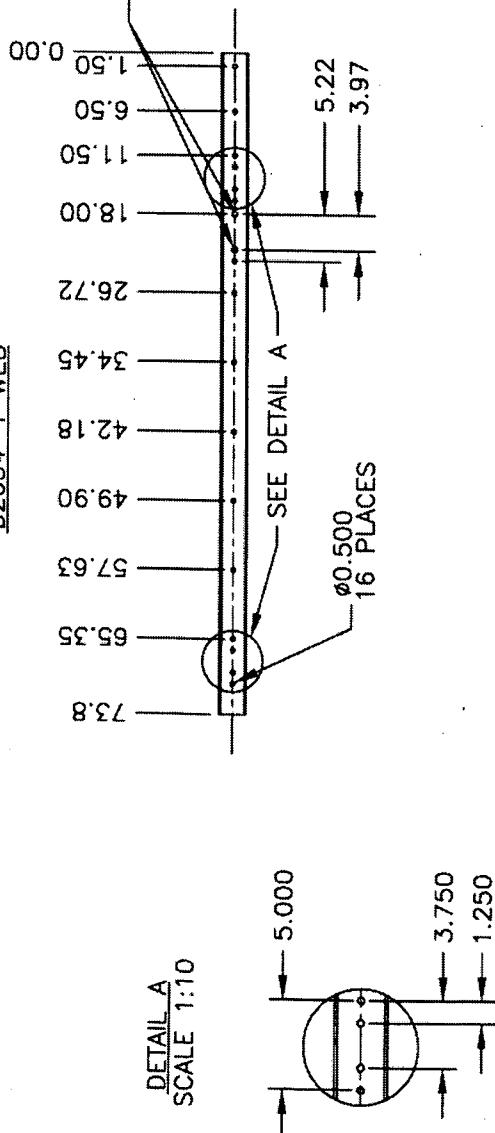


DESIGN <i>AC</i>	DRAWN BY <i>IP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D2654	REV. E SHEET 1 OF 2	
DATE 04.05.26		TITLE WEB	SCALE 1:20	
A	97.03.25	NEW ISSUE		
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29	CHANGED HOLE PATTERN		
D	98.01.15	GHW HOLES CHANGED TO $\varnothing 0.63$		
E	04.05.26	CHANGE LENGTHS, REFORMAT		
E1	<i>IP</i> 04.08.94	PER TOOLING; 80.8 WAS 80.5		

RELEASER
04.06.22 

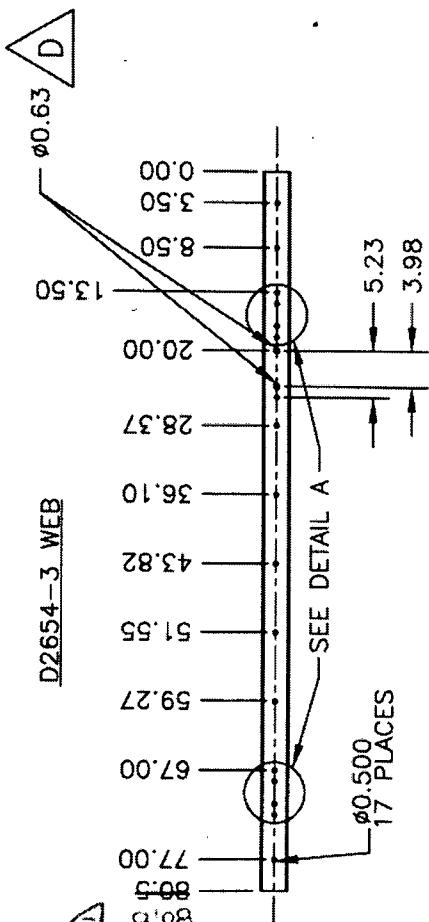
04.06.22 ~~aff~~

D2654-1 WEB



DETAIL A
SCALE 1:10

D2654-3 WEB



W/O 44280

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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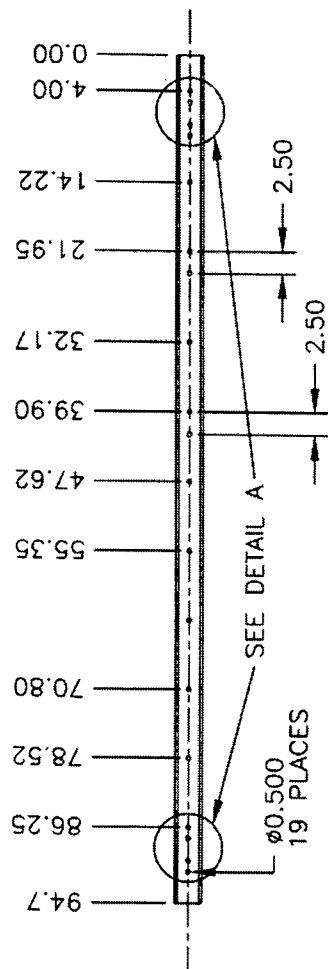
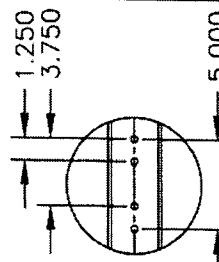
NOTE: Date & initial all entries

DART

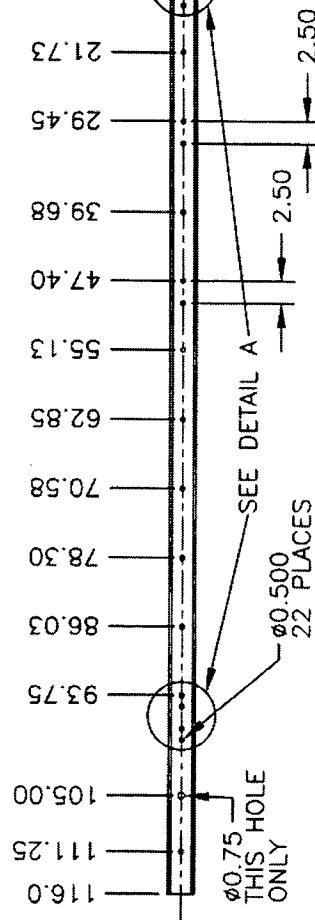
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654
DATE		REV. E SHEET 2 OF 2 TITLE WEB SCALE 1:20

RELEASED
04.06.22

D2654-5 WEB

DETAIL A
SCALE 1:10

D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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